

DART AEROSPACE LTD	Work Order:	24754
Description: Wearpad	Part Number:	D3340-09
Drawing: D3339 Rev. a D3340	Qty:	1
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	W	05.11.15	1
2	PG	Issue P/O: <u>7008674</u> Email or ship DXF file to vendor Laser Cut per Dwg D3339 flat pattern D3339-1 Material release note required D3340-9	W	05.09.19	1
3	RG	Receive and Inspect for transit damage Ensure the material note is attached	W	05.09.19	1
4	QC6	Inspect dimensions	W	05.09.19	1
5	GB	Deburr if necessary		N/A	
6	GB	Form on Brake as per Dwg D3339 using Jigs DT and DT D3340	SB	05/11/14	1
7	QC5	Inspect work to Step 7	W	05/11/10	1
6	GB	Weld hradcoat 7560 per dwg D3339 D3340 Pick: QTY description batch: A/R 7560 hradcoat M18838		N/A	
			W	05.11.14	1
7	QC9	Inspect welds			
8	FP	Powder Coat Grey sandtex (Ref. 4.3.5.6) per QSI 005 4.3	M	05.11.15	1
9	QC3	Inspect Powder Coat	CL	05/11/18	1
10	FP	Identify and Stock	W	05/11/15	1
11	AC	Cost / part: <u>14.60</u>	SUC	05-11-21	1
12	DC	Close W/O, <u>14.60</u> Inspect Level 21	W	05/11/21	1

Rev	Date	Change	Revised By	Approved
A	05.11.10	Preliminary issue	EC	W

PRELIMINARY ISSUE

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 10, 2005
07:04 am

Work Order No	:	0024754	Department Code:	
Project Name	:	D3340-9	Burden Flags	: NNNNNNN
Project For	:	WK547	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3340-9	Invoice Number	:
Description	:	Ctr Skidtube Protector	Invoice Amount	: 0.00
Manufactured	:	No	Order Entry No	:
Amount Req'd	:	0	OE Value	: 0.00
Amount Done	:	0		
Start Date	:	11-09-05	Est Margin	: 0.000%
Est Finish Date	:	11-24-05	Actual Margin	: 0.000%
Act Finish Date	:			
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:			

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

Date: Friday, 11/18/2005 1:08:41 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 24754		
Estimate Number	: 10762		
P.O. Number	:	Part Number	: D33409
This Issue	: 11/18/2005	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3340 REV A
First Issue	: / /	Project Number	:
Previous Run	:	Drawing Revision	: A
	Type : PURCHASED PARTS	Material	:
Written By	:	Due Date	: 11/25/2005
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est: A 05.11.10 Preliminary issue AP/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment: PURCHASING**

Issue P/O: _____

Email of ship DXF file to vendor

Laser Cut per Dwg D3340 flat pattern D3340-9

Material release note required

2.0	D33409F	Wearplate
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3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment: PACKAGING RESOURCE #1**

Receive & Inspect For Transit Damage

Ensure material release note is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment: DIMENSIONAL CHECK**

Inspect dimensions

5.0	BRAKE NC	NC BRAKE
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**Comment: NC BRAKE**

Deburr if necessary

Form on brake as per Dwg D3340 using Jigs DT and DT

Date: Friday, 11/18/2005 1:08:41 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 24754

Part Number: D33409

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Weld hardcoat 7560 per dwg D3340

Pick:

Qty	Description	Batch
A/R	7560 Hardcoat	_____

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

